- Work Order ID 52637

October 5, 2009, 10:41:54 AM

Item ID:

41232-200-004-001

Revision ID: IR

Item Name:

Reducer Tee Assembly

Start Date: 10/05/09

Required Date: 10/12/09

QC:

Start Oty: 6.00 Req'd Otv: 6.00



Accept



Run

Accept

Oty

Setup Start

Stop



Reference:

Approvals:

Process Plan:

Date:

Date:

SPC (Y/N):

Set Up/

Run Hours

Tooling:

Date: Date:

Draw

Rev.

Cust Item ID:

Customer:

Draw

Number

Plan

Code

Stop

Reject

Number

Reject

Oty

Start



Insp.

Stamp

Sequence ID/ Work Center ID Operation Description

Revision Nbr

41232-200-004

Rev IR

Draw Nbr

Lathe Conv

Conventional Lathe

CONVENTIONAL LATHE

Memo

0.00

1-Turn AN815-4J as per Dwg 41232-200-0041:2-Deburr as Required.

110

100

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

0.00

0.00

1-Drill as per Dwg 41232-200-00 12-Deburr

- Spot face 5/8 behavedilling

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

120

Quality Control

Memo

0.00

D ui 1 7 101	oopaoc	Liu									
W/O:			WO	RK ORDER CHANG	ES						
DATE	STEP	PRO	OCEDURE CHAN	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	•	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA :	Date: _				
	R	esolution:	Disposition	Disposition: Q/			A: N/C Closed: Date:				
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)					
DATE	STEP	Description of NC		Corrective Action Section		Verification	1 Approval	Approval			
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sign & Section C		QC Inspector			
		\$,					



Page 2

Item ID:

41232-200-004-001

Revision ID:

IR

Item Name:

Reducer Tee Assembly

Start Date:

10/05/09

OC:

Start Oty: 6.00

Required Date: 10/12/09

Req'd Qty: 6.00



Accept



Setup Start

Stop

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date: Tooling:

SPC (Y/N):

Date: Date:

Start Run

Sequence ID/

Work Center ID

130

Quality Control

Operation Description

OC8- Inspect parts - second check

Memo

Set Up/ **Run Hours**

Draw Number Rev.

Plan Accent Code Otv

Reject Otv

Number

Insp. Stamp

B. A 09/10/20

0.00

0.00

140

Large Fab

Large Fab

Large Fab

Memo

SS Rod

0.00

9-10-21

1-Weld as per Dwg 41232-200-004 LiA/R

Batch: M 108160

150

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

*1-WELD INSPECTION: 12-Pressure test as per Dwg 41232-200-004; 3-Passivate Finish.

QC5 enspeel work to current step => Salusles



Duit Ac	ospace	LIG						•	
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:			
Resolution:			Dispositio	n:	_ QA: N/C CI	Date: _			
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR	(1)			
DATE	STEP	Description of NC			ion B	Verification	Approval	Approval	
	SILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	

. Work Order ID 52637

October 5, 2009 10:41:55 AM

Item ID:

41232-200-004-001

Revision ID:

IR

Item Name: **Start Date:**

10/05/09

Reducer Tee Assembly

Required Date: 10/12/09

Start Qty: 6.00 Req'd Qty: 6.00

Reference:

Approvals:

Sequence ID/

Work Center ID

Process Plan:

QC:

Operation

Description

Date:

Date:

SPC (Y/N):

Tooling:

0.00

0.00

Set Up/

Run Hours

Identify as per dwg & Stock Location: 26

Packaging

Packaging

160

Memo

170

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Draw

Number

Date:

Rev.

Plan :

Code

Date:

Run

Accept

Qty

Start Stop

Reject Reject

Insp. Number Stamp

Qty

MF- 09-10-24

Dart Aerospace Ltd	Dart	Aeros	pace	Ltd
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W/O:			WO	RK ORDER CHAN	IGES		*				
DATE	STEP	PR	В	у ,	Date	Qty	Approval Chief Eng / Prod Mgr	Approvat QC Inspector			
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		,									
Part No:		PAR #:	Fault Categ	NCR: `	NCR: Yes No DQA: Date:						
	Res	solution:	Disposition	:	QA: N/	QA: N/C Closed: Date:					
NCR:			WORK ORDE	R NON-CONFOR	MANCE (N	NCR)					
DATE	STEP	Description of NC		Section B	Sign & Section C		Approval	Approval			
	Section A		Initial Chief Eng	Action Descriptio					Chief Eng	QC Inspector	
·		•									
		75.									

Picklist Print

- October 5, 2009 10:41:53 AM

Work Order ID: 52637

Parent Item:

41232-200-004-001RevIR

Parent Item Name: Reducer Tee Assembly

Comments:

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Purchased

union

AN815-4J

Start Date: 10/05/09

Start Otv: 6.00

Required Date: 10/12/09

Required Oty: 6.00

Bin Item

No

No

Primary Last Location Location

Route Seq ID

100

100

Unit of Measure

Each

Oty on Hand 20.0000

Remaining Oty Oty To Pick Issued Date Issued

Status

Purchased

Warehouse

Loc Qty

6.0000

Loc Code

Location

Main Warehouse

· ST 104253 20 20

Each

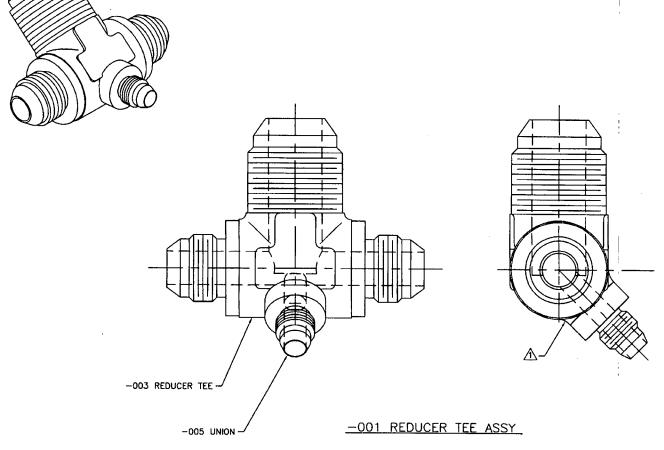
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TEE

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W/O:		·	V	VORK ORDER CHA	NGES						
DATE	STEP	PRO	OCEDURE CH		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvat QC Inspector		
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	:										
Part No	:	PAR #:	Fault Ca	tegory:	NCF	l: Yes I	lo DQ /	4:	_ Date: _		
						QA: N/C Closed: Date:					
NCR:		,	WORK OR	DER NON-CONFOR	RMANCE	(NCR))				
DATE	STEP	Description of NC	4	Section B	Verification		Approval	Approval			
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector	
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WO 52637

A PRESSURE TEST TO 3,000 PSI.

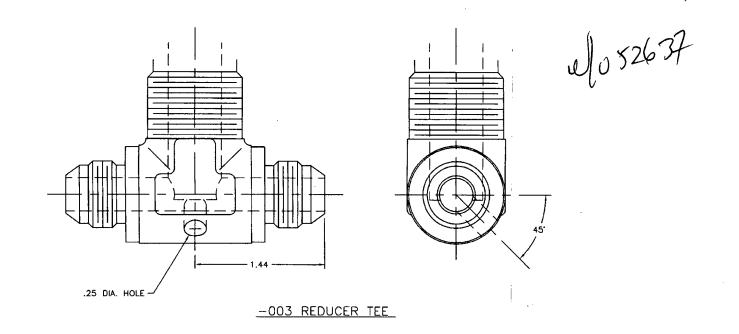
⚠ QQ-P-35 PASSIVATE FINISH AFTER WELD.

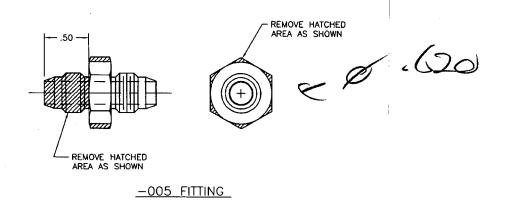
⚠ WELD IN ACCORDANCE WITH MIL-STD-2219 CLASS C.

NOTES:

						1	-005	UN	ION		MAKE	FROM	AN81	5-4J U	NION		T T
L						1	-003	RE	DUCER TE	E	MAKE	FROM	BELL F	P/N AS1	035J08	0812 or 110-	080-120
							-001	RE	DUCER TE	E ASSY							Π
F	NO.	RE	J.D	PER		-001 SY	PART NO.		NAME LIS	T OF	MATE	STOCK S	IZE	MATE	RIAL	MATL.SPEC	ZONE
	PROPR RIGHTS	NOT	CE						UNLESS OTHERWISE SPECIFIED	DRFTSMN	D. NE	LSON	5/24/02		DUCE	ER TEE AS	
ľ	ERA AMA MICLOSUA XUCTION, MICESE DATE TURPOSE	PIDN. BA BE, REPA OR USE A FOR B. FORE	형하는						X.±.1 XX.±.03 XXX.±.010	STRESS PROJ. DNGR.				DWG. SIZE	- C	SCALE 2:1	
1	AUTHORIZA BINA ANAK DINE FORME	ET WITH Chool FT CHOOL IN DOMES D	B723	-001	2	4	1232-000-001	yo.	ANGLES ±.1/2*	HEAT TREAT	A	Tra	Avis	attore,	Ino.	DWG. NO.	004 I D

W/O:			10//	DK ODDED C	HANCEC					
W/O:			VV	ORK ORDER C	HANGES			, ,		r
DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval- QC Inspector
				·						
				 						
Part No	:	PAR #:	Fault Cate	gory:	NO	R: Yes	No DQ	\ :	_ Date: _	
Resolution:					QA: N/C Closed: Date					
NCR:			WORK ORD	ER NON-CONF	FORMANC	E (NCR)			
DATE	STEP	Description of NC		Section B	Verific	ation	Approval	Approval		
DAIL	SILF	Section A	Initial Chief Eng	Action Desc Chief En		Sign & Date	Section		Chief Eng	QC Inspector
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Era Aviation, Inc.

REDUCER TEE ASSY

900. NO. 41232-200-004 SHT 2 OF 2